

Date: Monday, 8/13/2007 2:14:59 PM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPAD
Job Number : 33881	
Estimate Number : 12711	
P.O. Number : <u>N/A</u>	Part Number : D35373
This Issue : 8/13/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3537 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : SMALL / MED FAB	Drawing Revision : C
Previous Run : 33285	Material : <u>N/A</u>
Written By : <u>JLM 07-08-13</u>	Due Date : 8/20/2007 Qty: 60 Um: Each
Checked & Approved By : <u>JLM</u>	
Comment : Est Rev:A New Issue 07-02-14 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S16GA	304/316 .063 Sheet
-----	-----------	--------------------



Comment: Qty.: 0.1512 sf(s)/Unit Total : 9.0720 sf(s)
 M304S16GA Stainless steel sheet 0.063" thick
 Batch: M109130

SAN 07/08/13

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3537
 Dwg Rev: C
 Prog Rev: C

2-Deburr if necessary

SAN 07/08/13

60

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAN 07/08/13

60

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

En 07/08/14

caen
(60)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. Identify as D3537-3
 Form Joggle as per Dwg D3537 on brake using Jig DT8158

SB 07/08/22

SB 07/08/23

(60)
(60)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 33881

Part Number: D35373

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0

QC5

INSPECT WORK TO CURRENT STEP



center

Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

En 07/08/23

(60)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description
A/R 2059B Hardcoat
Weld hardcoat as per Dwg D3437

Batch
m105315/14105465

07/09/10

(60x)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/09/11 (60)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/09/11 (60)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m104846

04-09-12

(60)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m1 07 09 12

(60)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: F.P

m1 07 09 12

(60)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

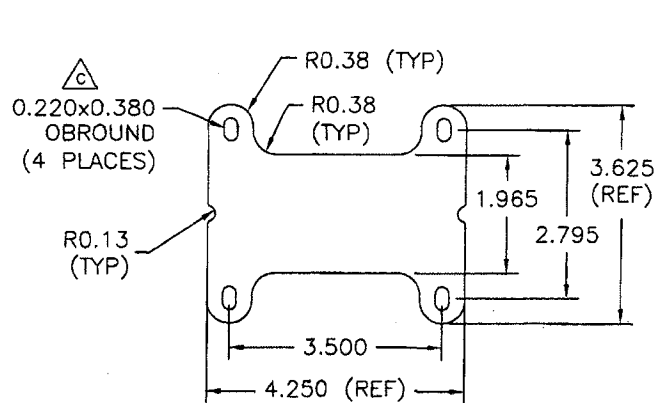
07/09/13

Job Completion

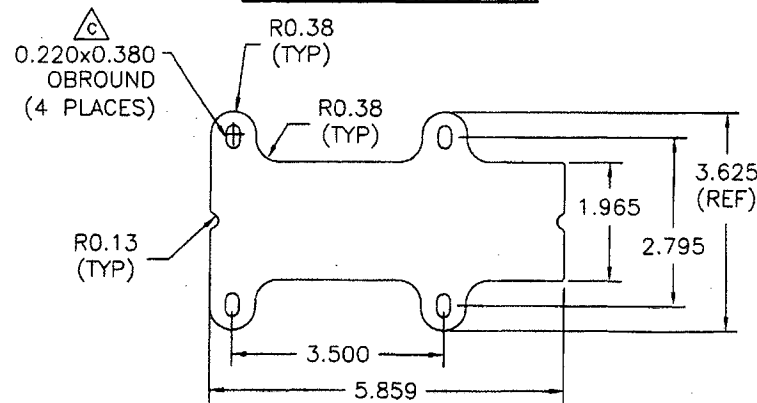


07/09/13

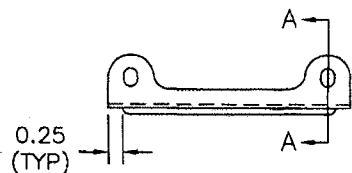
D3537-1F FLAT PATTERN



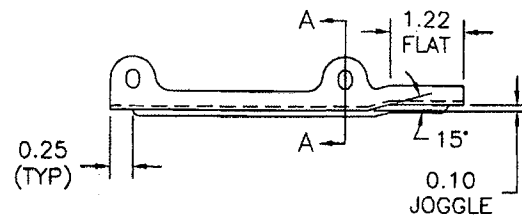
D3537-3F FLAT PATTERN



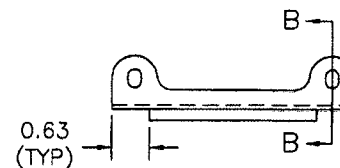
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



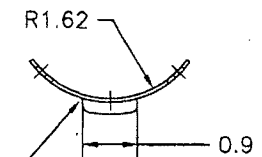
D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-1/-3/-5/-7 WEARPAD NOTES

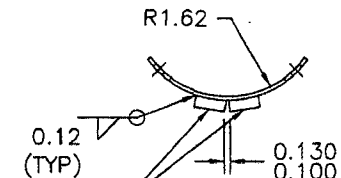
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SECTION A-A



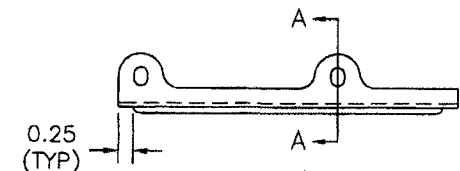
APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

SECTION B-B



D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	C.B.	DRAWN BY P.H.
CHECKED	A	APPROVED A
DATE	07.04.13	DRAWING NO. D3537
		TITLE WEARPAD

COPYRIGHT © 2006 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

DART DART AEROSPACE USA, INC.
PORT HADLOCK, WA

REV. C
SHEET 1 OF 1
SCALE
1:2

RELEASED
07.05.08 Ad
per ECLN
962